Work Orde				*	108	670*							Page 1
Item ID: Revision ID: Item Name:	D3235-1 Mounting Lug			Accept		*N900) 040	100) *	Setup	Start Stop	I VI	S1* S2*
Start Date: Required Date: Reference:	10/28/2013 10/31/2013	Start Qty: 100.0 Req'd Qty: 100.0				Cust Item Customer							
Approvals:	Process Pla	ın: CZ	Date: 13/10/25				Date:		1	Run	Start Stop	*N	R1*
Sequence ID/ Work Center II		Operation Description		Set l		Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	R2* Insp. Stamp
Draw Nbr	Rev	ision Nbr											
D3235	Rev	A											
*110 *110* Outsource5 Outsource process -	Machining	Outsource process - Me HAAS CNC VERTICA Memo Issue P/O Machine a C of C is r	AL MACHINING #1 to Metec: 21848 s per dwg	0.00					<u> </u>	L,	1311	0/28	8 (160)
*120 *120* Packaging Packaging		Receive & Inspect for I Memo Ensure C o	Damage & Mat'l Certs of C is attach	0.00								3/4/	(v) (100
130 *130* QC Quality Control		QC6- Inspect dimensio	ons to drawing	0.00	DAS 27 9-69)		1	con d				

NCR:	Yes	/	No

											DQA:	Date:	
NCR: Y	'es	/ No				WORK ORDER NO	N-CON	IFORN	MANCE / UPDATE		•		
										(QA Closed:	Date:	
Nork Orde	r:					DISPOSITION			AGAINST	DEP	ARTMENT/	PROCESS	
Part N	– _ lo					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descr	ription of work order updat	te l	nitial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
oc/Data quip/Tooling perator Material											,		
etup Other											•		
rocess													
upplier raining													
napproved													
							FAUL	T CATE	GORY				
Landi					_	General .		۱		\Box	Ovalized		Pressure/Forced
i	_	Bending			~ <u> </u>	Bend		Grain		\mathbf{H}	Ovalized Over/Under	+-laranaa	Temperature/Cure
	_	Centre No	t Concer	ntric to (^{3/5} -	BOM/Route		Hardwa		\mathbf{H}	Part Incorred	 	Weld
	\vdash	Cracks Crushed/(^rimnod		}-	Broken/Damaged Burrs	-	i	ion Incomplete ions Incomplete/Unclear	\vdash	Part Hicorrec	<u> </u>	Wrong Stock Pulled
	_	Crusneu/ Cuffs	Limped			Contamination		Mainte	· ·	\vdash	Part Moved	J31116	J. T. Olig Stock Talled
:	\vdash	Cuns Heat Trea	t		<u> </u>	Countersink		Mislabe		\mathbf{H}	Positioned V	Vrong	
	\vdash	Inspection	_	Tube	-	Cut Too Short	-	Misread		\vdash	Power Loss/		Other
	-	Ripples in			T	Drill Holes		Offset		_	·		
	$\boldsymbol{\vdash}$	Torque W		xtrusio	n	Drawing		Out of (Calibration	-			
	-	Turning S				Finish		Out of S	Sequence	_			
	-	Wave/Tw				Folio		Outside	Dimensions	-			

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Work Orde Monday, Octobe				*108	3670*						Page 2
Revision ID:	D3235-1 Mounting Lug	5	÷	Accept	*N900	040	100)* s	Setup Sta	1.0	S1* S2*
Start Date: Required Date: Reference:	10/28/2013 10/31/2013	Start Qty: 100.00 Req'd Qty: 100.00	*100 *100		Cust Item 1 Customer:	ID:					
Approvals:		ın:	Date:			ate:		I	Run Sta Sto		R1* R2*
Sequence ID/ Work Center II 140 *120* HandFinish Hand Finishing 150 *150* QC Quality Control		Operation Description Chemical Conversion Coa Memo QC3- Inspect Part Finish Memo	t per QSI005 4.1	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty		Reject Number	Insp. Stamp 13-16-6 DAS 34 9-89
160 *160* Powdercoat Powder Coating		White Gloss(Ref.4.3.5.1) Memo START TIME OVEN TEME FINISH TIME	e: <u>12:00</u> peratube: 320°	0.00				<i>J00</i>	<i>\(\beta \)</i>	13- H -	7. DAS 34 9-89

NCR: Y	es / No)			WORK ORDER NON-	CON	IFORM	MANCE / UP	DATE			
										QA Closed:	Date	2:
Work Orde	r:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	⊣	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	1		T T	Nescri	ption of work order update		nitial	Δct	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	- 1	ief Eng		ription	Date	Verification	QC Inspector
quip/Tooling perator Material etup Other rocess upplier raining												
1		I	1 -	1		FAUL	T CATE	GORY		<u></u>	<u> </u>	
Landin	Bendir Centre Cracks Crushe Cuffs Heat T	Not Conce	l	o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		•	ion Incomplete ions Incomplete/U enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
}	— 1 ' ' '	Waves in	Extrusio	,	Drawing		•	Calibration				
<u> </u>	-	a Seguence		-	Finish		1	Seguence				

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Order ID 108670

108670

Page 3

Monday, October 28, 2013 10:11:37 AM Accept D3235-1 *N900040100* Item ID: Setup Start **Revision ID:** Item Name: Mounting Lug **Start Qty:** 100.00 *100* **Start Date:** 10/28/2013 **Cust Item ID: Required Date:** 10/31/2013 Req'd Qty: 100.00 *100* **Customer:** Reference: Run Start Date: **Tooling:** Approvals: Process Plan: Date: Stop Date: SPC (Y/N): Date: Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Sequence ID/ Operation Qty Number Stamp **Work Center ID** Code **Qty** Description **Run Hours** 0.00 170 QC3- Inspect Part Finish DAS ROS *170* 27 0.00 OC Memo **Quality Control** 131108 Identify as per dwg & Stock Location: 5T470 0.00 180 100 × 28 13-11-11 *180* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 190 *190* 0.00 QC Memo Quality Control

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Picklist Print

Monday, October 28, 2013 10:11:37 AM

Page 1

Work Order ID:

108670

Parent Item:

D3235-1

Parent Item Name:

Mounting Lug

Start Date: 10/28/2013

Required Date: 10/31/2013

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP A04.04.19New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measu	Qty on re Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No				f	491.8000		8	allin	11.	^
Lug Extrusion											CO 13	11015	<u> </u>
				Location		Loc Qty		Loc Code					
				MAT006		491.8							
				105	5422	320							
e ^{ja}				879	953	171.8				<u>8</u> _	1		
D3235-1P		Purchased	No				Each	0.0000		100	16.01		

										DQA:	Date	!:
NCR: Y	es / No				WORK ORDER NON	-COI	VFOR	MANCE / UP	DATE	OA Classed	D-4-	
							***			QA Closed:	Date	! :
Work Orde	r:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N NCR N					Rework Scrap Use-as-is			Skid-tube Machining Moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
INCK IN	o				Work Order Update			Large Fab	Composite		Supplier	_
Root					'		nitial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Ooc/Data quip/Tooling Operator												
/laterial												
etup			}									
Other											ļ	
rocess												
Supplier												
raining						·						
Jnapproved												
						FAUL	T CATE	GORY				
Landin	ng Gear				General						_	
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
1	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs	L	Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Tre	eat			Countersink		Mislabe	eled	L	Positioned V		
	Inspecti	on Strip in	Tube	L	Cut Too Short		Misread	t	L	Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes		Offset					
	Torque '	Waves in I	Extrusio	n [Drawing		Out of 0	Calibration				
	Turning	Sequence	:		Finish		Out of	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio





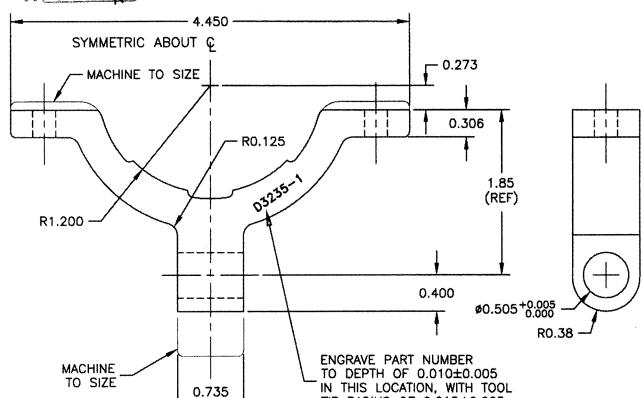
A

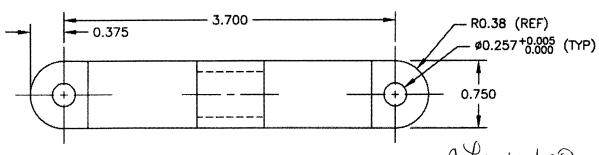
	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		******	
7	CHECKED	APPROVED	DRAWING NO.	REV	1. 1	Ā
	#	-	D3235 SHEET	1 0	F	1
	DATE		ПЕ	SC	AU	Ē
	04.03.02		MOUNTING LUG		1:	1

04.03.02 | NEW ISSUE

TIP RADIUS OF 0.015±0.005

ELEASE O40405





D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

(REF)

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CZ13110/28

W10'. 108670



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Tel: 613 632 9577

Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO21848

Purchase Order Date 10/28/2013 **PO Print Date** 10/28/2013

Page Number 1 of 2

Order From:

VC-MET003

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

 $\mathsf{C}\mathsf{A}$

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

613 678 3957

METEC METAL TECHNOLOGY INC.

20 TERRY FOX DRIVE PO BOX 781

VANKLEEK HILL, ON K0B 1R0

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

Terms

10127-2607 Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ CD Taxable Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2230-1P	Lug	10/30/2013	149.00	\$18.95	\$2,823.55
		C	Yes	Each		
			10/30/2013			
	AS PER DWG D2230 REV. G B108669					
					Line Total:	\$2,823.55
2	D2230-3P	Lug	10/30/2013	257.00	\$13.60	\$3,495.20
		Ŭ	Yes	Each		
			10/30/2013			
	AS PER DWG D2230 REV. G B108668					
					Line Total:	\$3,495.20
3	D3235-1P	Lug	10/30/2013	100.00	\$15.05	\$1,505.00
			Yes	Each	_	•
	40 PPP DWO D2226 PPV 4 7	•	10/30/2013	•		
	AS PER DWG D3235 REV. A *					

Note:

B108670



20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0 , Canada

Tel: (613) 678-3957 Fax: (613) 678-3956

Delivery Slip No.:

19314

Date:

Oct 28, 2013

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO21848	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Ünit.	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug	Each		149	
D2230-3 Mounting Lug	Each		257	
D3235-1 Mounting Lug	Each		100	
		_		
	3er 4			
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	e gath of			
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by	Thanl	k vou for vo	ur order!	

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20 Terry Fox Drive, Vankleek Hill, Ontario KOB 1R0 Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street

Hawkesbury, Ont.

K6A 1K7

same

QUANTITY	PART NUMBER	PART NAME	P.O. NUMBER
149	D2230-1	Lug	21848
257	D2230-3	Lug	21848
100	D3235-1	Lug	21848

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, October 28, 2013

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